

**Work Order ID 61734**

Tuesday, August 31, 2010 3:14:36 PM



Page 1

Item ID: D206-667-103TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Turning DetailL

Start Date: 8/31/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: 

Date: 10-8-31 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-143	Rev C								

100

0.00



Mori Seiki


MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA087□2-Turn first side as per Folio FA087□3-File down transition lines smooth.

 MB 10-08-01

110

0.00




QC

QC1- Inspect dimensions to dimension sheet

Memo

0.00

Quality Control

 MB 10-09-01

120

0.00



Mori Seiki


MORI SEIKI CNC LATHE LARGE

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA087□2-File down transition lines smooth.  
□  
3-Remove sand and plugs

 MB 10-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-667-103TRN PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>61734</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.09.07	100	Cuff O.D below tolerance by 0.008 P.L offset was wrong	CP 10.09.07 AS/042	Acceptable	MB 10-09-08	S 10/02/08	CP 10.09.07 AS/042	S 10/02/08

NOTE: Date & initial all entries

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Page 2

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Required Date: 9/13/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC1- Inspect dimensions to dimension sheet	0.00							
QC	Memo	0.00							
Quality Control									
140	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
150	Crosstubes Chemical Conversion	0.00							
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes									

110

2 MB 10-09-01

10

Pho →  
1st Phase  
(Back)

DP

10-8-8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Revision ID:

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Start Date: 8/31/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

(14) MB 10-09-08

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack ☐ Location: LGSAD  
10-09-08

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/09

10-09-08

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, August 31, 2010 3:14:41 PM

Page 1

Work Order ID: 61734



Parent Item: D206-667-103TRN



Parent Item Name: Crosstube Turning DetailL

Start Date: 8/31/2010

Required Date: 9/13/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-03-06 new issue DD verified by:ec  
IPP Rev B 08.04.02 removed polish EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6002-115

Manufactured

No

110

Each

52.0000

1

1



Crosstube Material



MB 10-09-01

Location

Loc Qty

Loc Code

LG

52

34684

1

34776

51



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 61734
<b>Description:</b> Crosstube Assembly (206L High Fwd)		<b>Part Number:</b> D206-667-143
<b>Inspection Dwg:</b> D206-667-143 <b>Rev:</b> B C		<b>Page 1 of 1</b>

10-09-03  
**FIRST ARTICLE INSPECTION CHECKLIST**

☒ **First Article**      ☐ **Prototype**

	Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.232		✓	Am-04	Acceptable CP 10.09.07
	1.982	+0.005/-0.000	1.982	✓		u	
	2.019	+0.005/-0.000	2.019	✓		u	
	2.058	+0.005/-0.000	2.058	✓		u	
	2.097	+0.005/-0.000	2.099	✓		u	
	2.136	+0.005/-0.000	2.138	✓		u	
	2.176	+0.005/-0.000	2.178	✓		u	
	2.201	+0.005/-0.000	2.201	✓		u	
	0.125	+/-0.010	0.125	✓		Am-04	
	0.400 x 30°	+/-0.010	0.400 x 30°	✓		u	
	R0.063	+/-0.010	R0.063	✓		R-G	
	R0.500	+/-0.010	R0.500	✓		R-G	
	4.438	+/-0.030	4.438	✓		Am-04	
SIDE B	104.98	+/-0.020	104.98	✓		Am-04	
	2.240	+0.005/-0.000	2.239		✓	Am-04	Acceptable CP 10.09.07
	1.982	+0.005/-0.000	1.982	✓		u	
	2.019	+0.005/-0.000	2.023	✓		u	
	2.058	+0.005/-0.000	2.064	✓		u	
	2.097	+0.005/-0.000	2.102	✓		u	
	2.136	+0.005/-0.000	2.141	✓		u	
	2.176	+0.005/-0.000	2.181	✓		u	
	2.201	+0.005/-0.000	2.206	✓		u	
	0.125	+/-0.010	0.125	✓		Am-04	
	0.400 x 30°	+/-0.010	0.400 x 30°	✓		u	
	R0.063	+/-0.010	R0.063	✓		R-G	
	R0.500	+/-0.010	R0.500	✓		R-G	
	4.438	+/-0.030	4.438	✓		Am-04	

<b>Measured by:</b> MB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-09-02	<b>Date:</b> 10/09/03	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.05.06	New Issue (P/O D206-667-103)	KJ/RF	
B	06.03.09	Dwg Rev updated	KJ/JLM	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

Item	Qty -143	Part Number	Description
1	X	D206-667-143	CROSSTUBE ASSEMBLY (206L HIGH FWD)
2	1	D6002-115	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

#### GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6002-115  
FINISHED LENGTH = 104.98±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-143" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 15.5 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *61239*  
*BP 10-831*

RELEASED  
*28/11/12*

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCE (ZN D3-3, C4-3, C5-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>9</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>9</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>9</i>	D206-667-143	SHEET 1 OF 4
APPROVED	<i>9</i>	TITLE	SCALE
DE APPR.	<i>9</i>	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

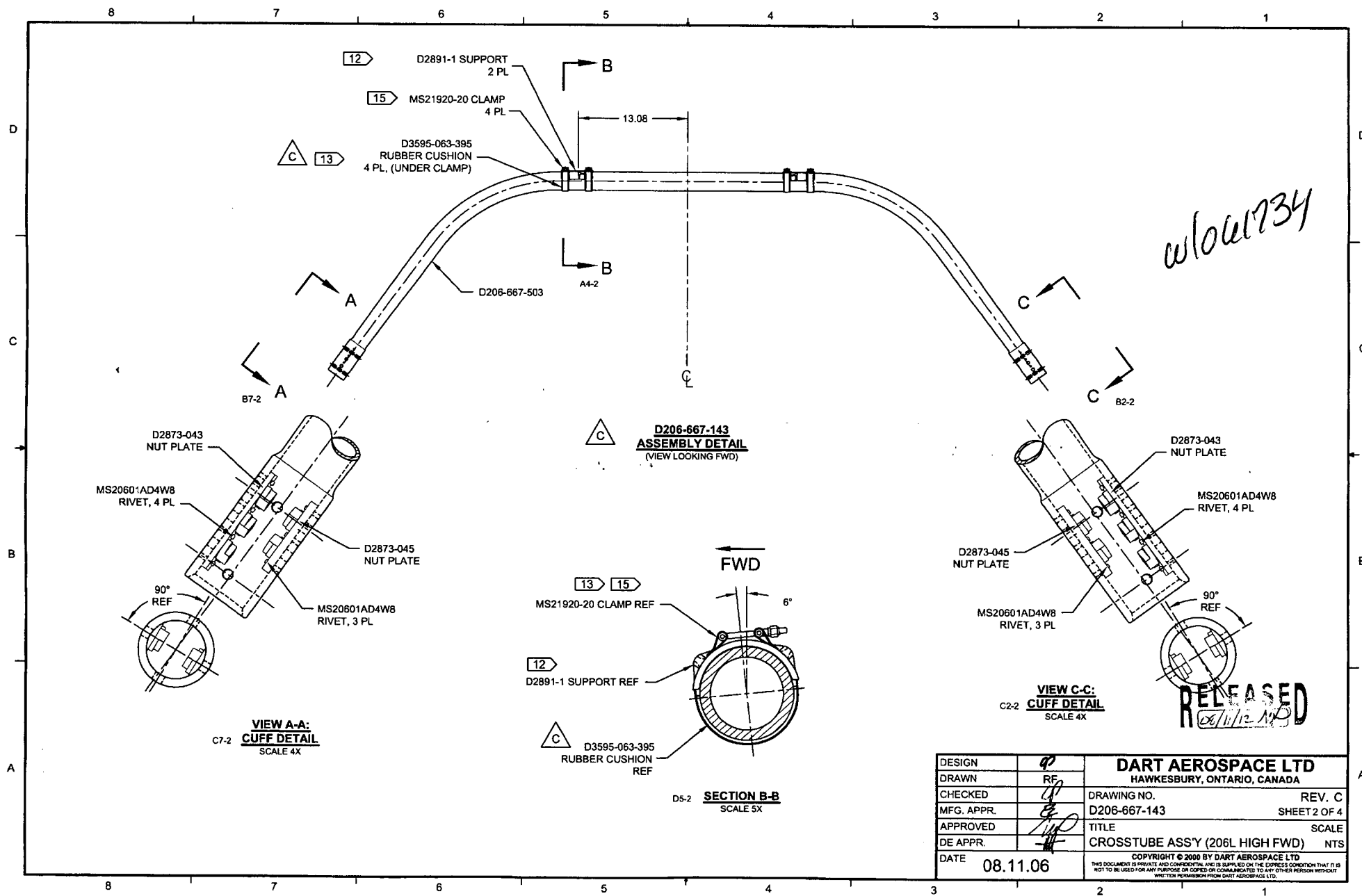
W/O:		WORK ORDER CHANGES					
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DESIGN	90	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	48	DRAWING NO.	REV. C
MFG. APPR.	8	D206-667-143	SHEET 2 OF 4
APPROVED	14	TITLE	SCALE
DE APPR.	14	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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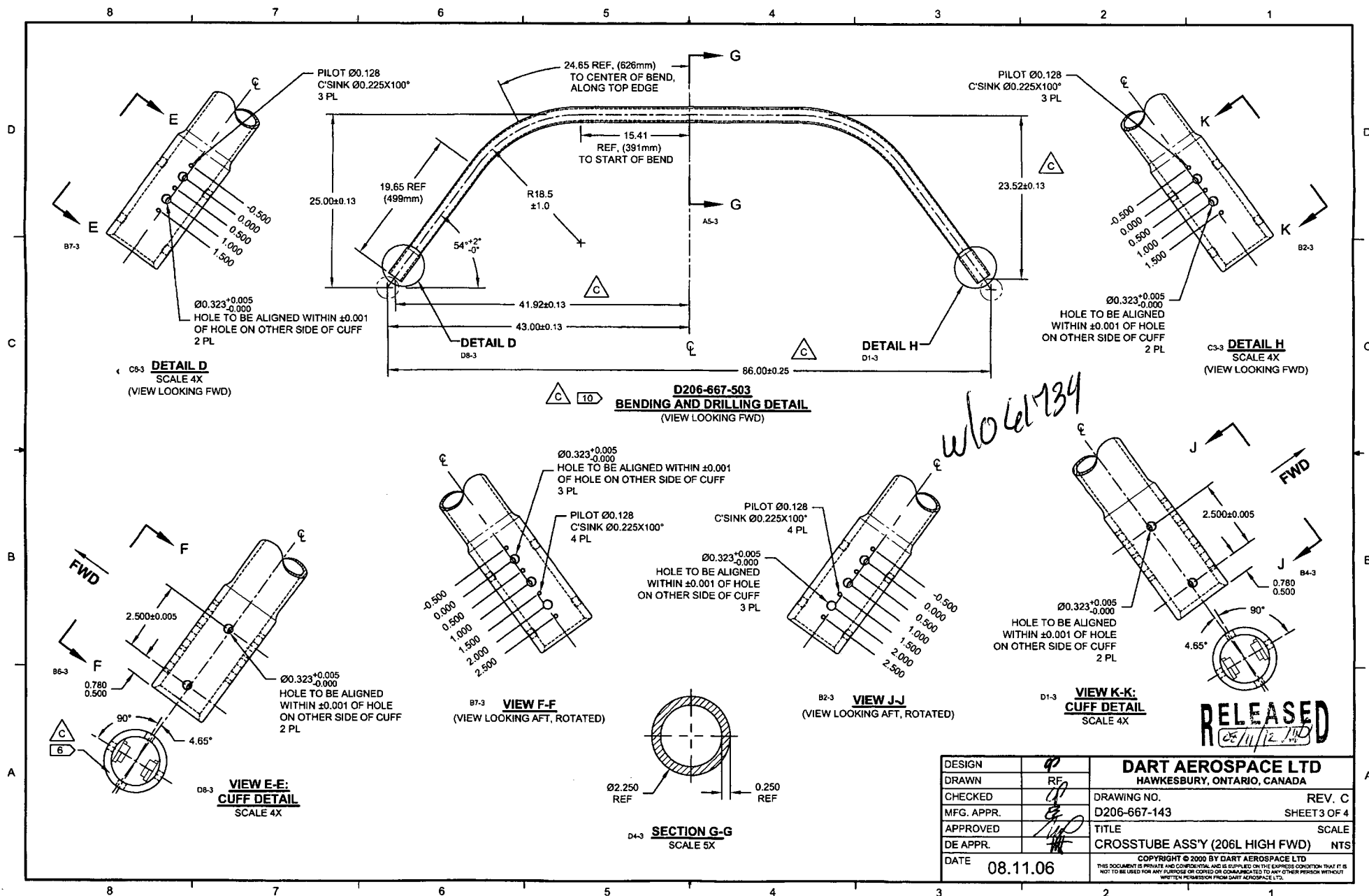
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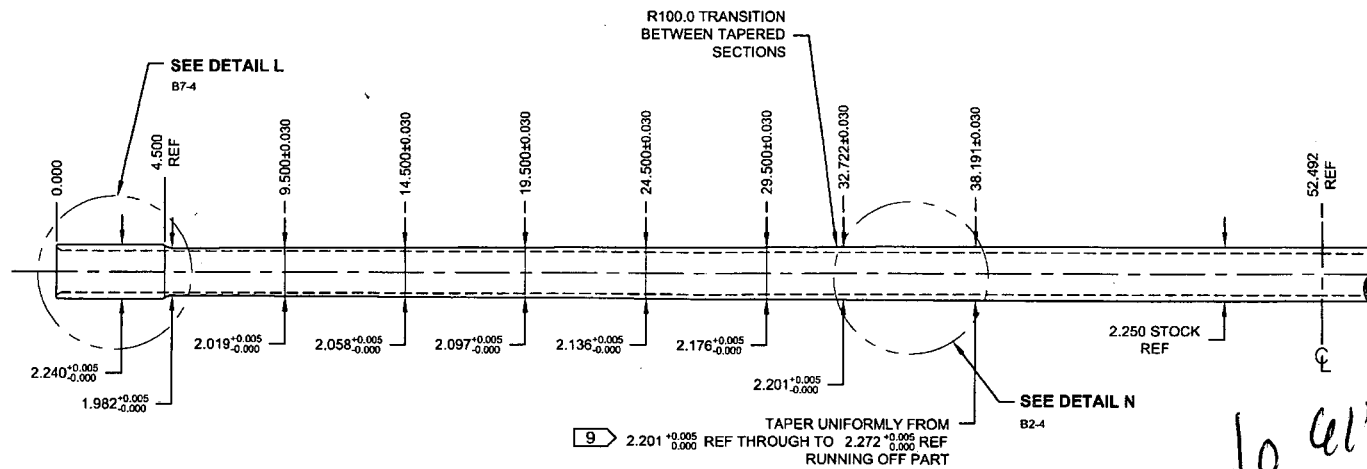
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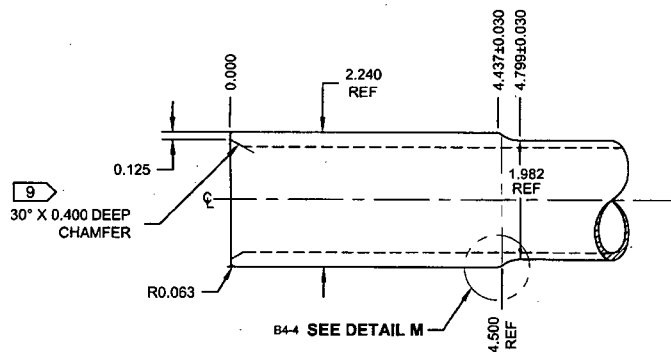
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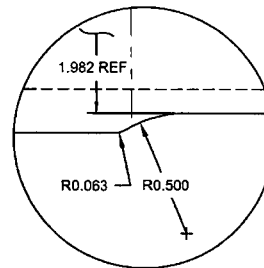


arlo 61734

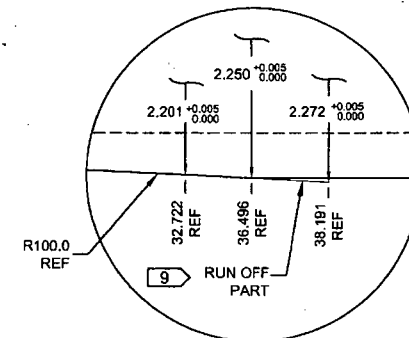
**TURNING DETAIL**



**DETAIL L:**  
D7-4 CROSSTUBE CUFF  
NOT TO SCALE



**DETAIL M:**  
A6-4 CUFF TRANSITION  
NOT TO SCALE



**DETAIL N:**  
C4-4 TAPER RUN-OFF  
NOT TO SCALE

**RELEASED**

DESIGN	9	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D206-667-143	SHEET 4 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CROSSTUBE ASS'Y (206L HIGH FWD)	NTS
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